

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000903**Date Inspected:** 20-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Lujian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Mock-up 89 & 114**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe welding operations of the Orthotropic Box Girder (OBG) fabrication and Magnetic Particle Testing (MT) of the 89.00 and 114.00 meter mock-up, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector witnessed ZPMC QC Zhou Dongyun perform Magnetic Particle Testing (MT) of 114.00 Meter Mock-up Skin Plate E MA108 welds 7 and 8. Mr. Dongyun also performed MT of 114.00 Skin E MA108 lifting device removal areas. The above mentioned MT was found acceptable by Mr. Dongyun.

Caltrans QA Inspector Viars witnessed ZPMC QC Mr. Zhou Dongyun performing MT of 77.00 Meter Mock-up Face A Plate stiffener excavation areas. Excavation areas were reported as acceptable by Mr. Dongyun. The following welds and excavation total were recorded by Caltrans QA Inspector Viars. Weld # 2 had two excavation areas and appeared to be approximately 90 mm in length weld # 3 had one excavation area also approximately 90 mm in length. The measured depth ranged from approximately 31 to 34 mm. Please see the attached photo below of the excavation area.

ZPMC QC Mr. Shen Xue Jun reported 3 cracks were found on OBG T stiffener to plate tacks welds on SP018 weld # SP018-01-14. Caltrans QA inspector Viars was informed by Mr. Shen Xue Jun that these areas would be excavated MT performed and Visual performed by a ZPMC Certified Welding inspector prior to repair.

Caltrans QA Inspector monitored Magnetic Particle testing performed random visual inspection of welding .See

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MT report TL 6038, generated on this date for further information.



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
